



# Work Order ID 52568

October 1, 2009 2:30:08 PM


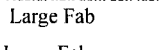


Page 1

Item ID: D3451-047 **GN** Accept  Setup Start   
Revision ID: A Stop   
Item Name: Handle and Lock-Down Assembly  
Start Date: 10/02/2009 Start Qty: 4.00  Cust Item ID:  
Required Date: 10/12/2009 Req'd Qty: 4.00  Customer:  
Reference:


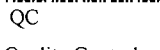
Approvals: Process Plan: **mf** Date: **09-10-01** Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3451	Rev A								



100  Large Fab 0.00  
 Large Fab Memo 0.00  
Large Fab Weld as per dwg PB67-43001

(4)

**Pl 09 10 05**

110  QC9- Inspect visual per QSI004- Fusion Welds 0.00  
 QC Memo 0.00  
Quality Control

**09.10.07**

120  QC5- Inspect part completeness to step on W/O 0.00  
 QC Memo 0.00  
Quality Control

**⇒ 507/10/06**

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

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Item ID: D3451-047

Accept



Setup Start



Revision ID: A

Stop



Item Name: Handle and Lock-Down Assembly

Start Date: 10/02/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/12/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- assemble rubber handle as per dwg PB67-43001								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
180 	Identify as per dwg & Stock Location: <u>442</u>	0.00							
Packaging	Memo	0.00							
Packaging									

9/30/09/10/09 (4)

2/8/09/10/09

(78)

10/9/10/09 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

**Work Order ID 52568**

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Page 4

Item ID: D3451-047

Accept



Setup Start



Revision ID: A

Stop



Item Name: Handle and Lock-Down Assembly

Start Date: 10/02/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/13

MK  
09-10-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 52568

Parent Item: D3451-047RevA

Parent Item Name: Handle and Lock-Down Assembly


Comments:

Start Date: 10/02/2009

Required Date: 10/12/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3451-7RevA  Tube Handle Arm		Manufactured	No			100	Each	16.0000	8.0000			

*Cpl 09.10.02*

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

16

41462

16

GP-211

Purchased

No

100

Each

28.0000

8.0000



Rubber Handle

*8 ✓*

*Cpl 09/10/09*

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

28

109006

4

111076

24

PB67-43001-103RevC

Manufactured

No

100

Each

0.0000

4.0000



Tube Handle

*M112852 (8X)*

*Cpl 09.10.02*

*B41473 → 1 \**

*B52570 → 3 ✓*

W/O:		WORK ORDER CHANGES					
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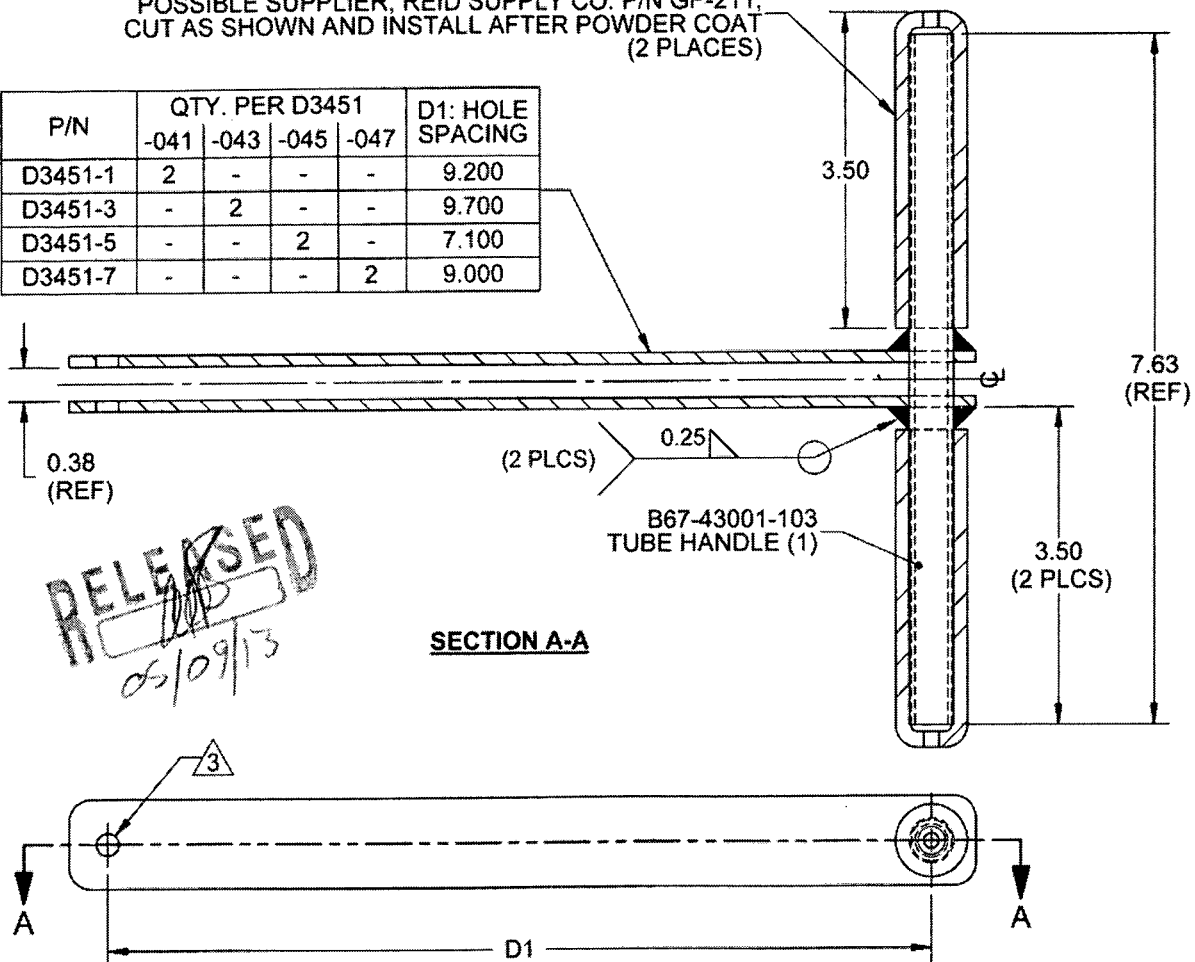
**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3451</b>	REV. A SHEET 1 OF 2
DATE <b>05.08.25</b>		TITLE <b>HANDLE &amp; LOCK-DOWN ASS'Y</b>	SCALE 1:2
A	05.08.25	NEW ISSUE	

0.50" ID x 4.875" LONG BLACK VINYL HANDLE,  
POSSIBLE SUPPLIER, REID SUPPLY CO. P/N GP-211,  
CUT AS SHOWN AND INSTALL AFTER POWDER COAT  
(2 PLACES)

P/N	QTY. PER D3451				D1: HOLE SPACING
D3451-1	2	-	-	-	9.200
D3451-3	-	2	-	-	9.700
D3451-5	-	-	2	-	7.100
D3451-7	-	-	-	2	9.000



**D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y**

**D3451-041 SUPERSEDES PREMIER P/N B67-43001-41**

**D3451-045 SUPERSEDES PREMIER P/N B67-43001-39**

**D3451-047 SUPERSEDES PREMIER P/N B67-43001-55**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) PART IS SYMETRICAL ABOUT CENTER LINE.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

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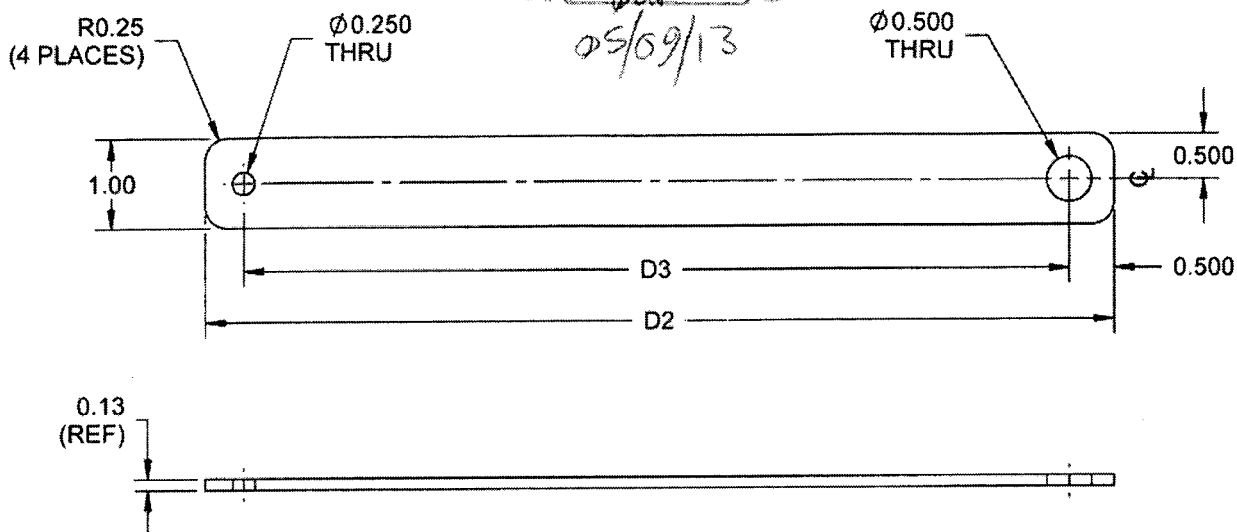
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**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3451</b>	REV. A SHEET 2 OF 2
DATE <b>05.08.25</b>		TITLE <b>HANDLE &amp; LOCK-DOWN ASS'Y</b> SCALE 1:2	

**RELEASED**  
*[Signature]*  
05/09/13

P/N	D2: CUT LENGTH	D3: HOLE SPACING
D3451-1	10.25	9.200
D3451-3	10.63	9.700
D3451-5	8.00	7.100
D3451-7	10.00	9.000

**D3451-1/-3/-5/-7 TUBE HANDLE ARMS**

**D3451-1 SUPERSEDES PREMIER P/N B67-43001-303**  
**D3451-5 SUPERSEDES PREMIER P/N B67-43001-301**  
**D3451-7 SUPERSEDES PREMIER P/N B67-43001-101**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.125)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE.
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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